

Date: Wednesday, 7/12/2006 3:23:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END CAP
 Job Number : 27873
 Estimate Number : 11671
 P.O. Number : N/A Part Number : D28491
 This Issue : 7/12/2006 S.O. No. : N/A Drawing Number : D2849 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : *See comment below* Due Date : 7/30/2006 Qty: ²¹/₂₀ Um: Each
 Checked & Approved By : *06.07.12*
 Comment : Est. B 08.12.07 Changed folio DM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X01500 6061-T6 Bar 2.5" x 1.5"

Comment: Qty.: 0.3368 f(s)/Unit Total: 6.7368 f(s) *M12867 x 2*

6061-T6 Bar 2.5" x 1.5"

6061-T6 2.5" X 1.5"

Batch *M9877 x 19**J.F.**06/08/04**21*

2.0 SHEAR SHEAR

Comment: ~~SHEAR~~ *Band saw*

Shear blanks: 3.8"

*J.F.**06/08/04**21*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2849-1

Deburr and Tumble

*9mL / J.F.**06/08/04**21*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*9mL / J.F.**06/08/04**21*

5.0 PACKAGING 1 PACKAGING RESOURCE #1


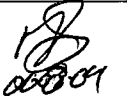
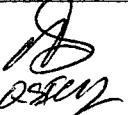
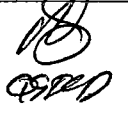



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST389**AL 06/08/09**(21)**4.1 QCL8**Second check**J.G.**06/08/08**21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/04	3	The y origine was 1004" off. Made a little groove in the piece.		Scrap & replace	J.F. 06/08/04			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 27873

Part Number: D28491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



(21)

Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/08/10

Job Completion



U 06-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

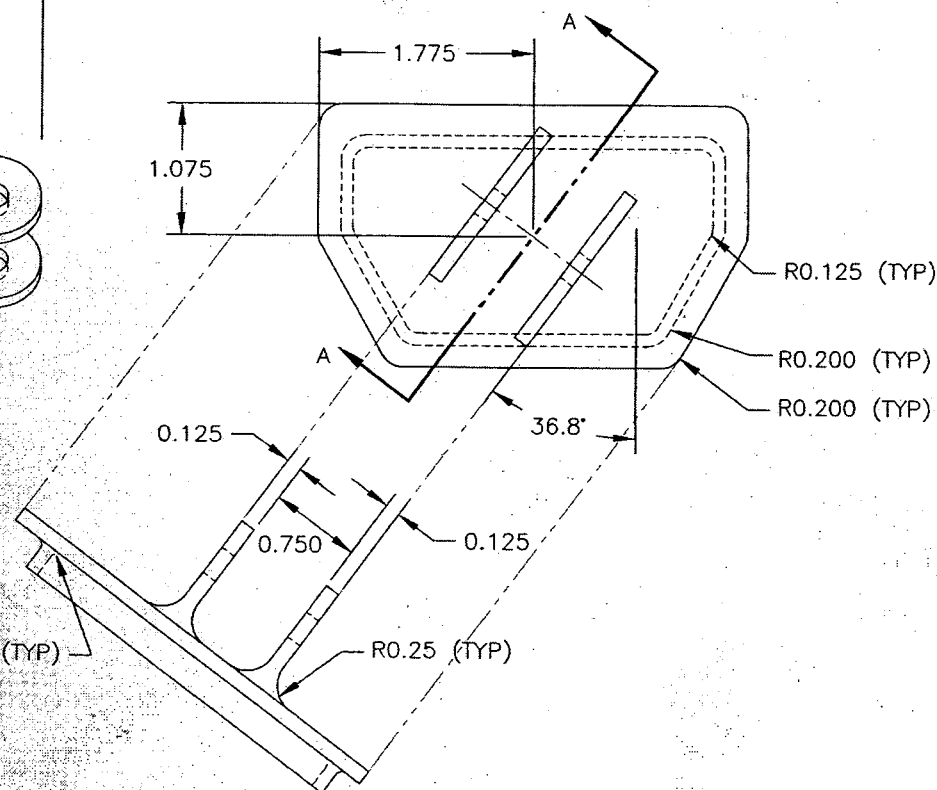
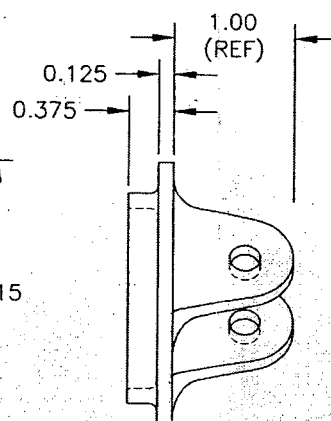
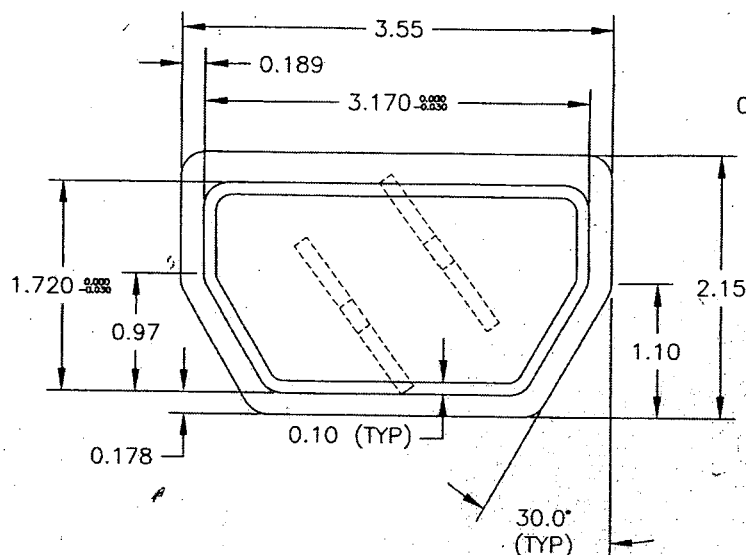
FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

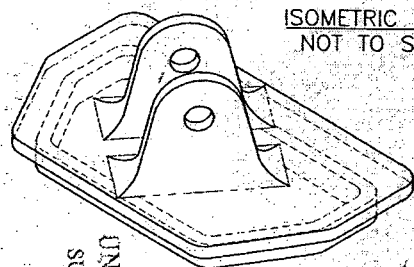
Measured by: J.F.	Audited by: JG	Prototype Approval:
Date: 06/08/04	Date: 06/08/04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



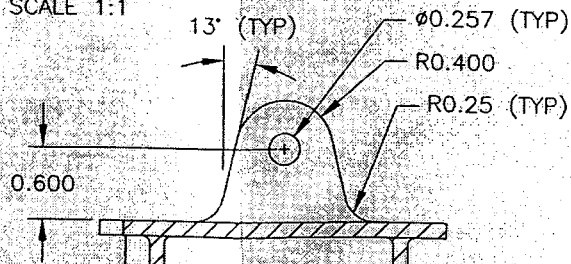
R0.063 (TYP)

D2849-1 (SHOWN)
D2849-2 (OPPOSITE)
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: NONE
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
98.11.25 KE



A	98.11.10	NEW ISSUE, REPLACES D2358 REV. B AND D2359 REV. A
DESIGN	DP	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED	KE	DRAWING NO. D2849
DATE	98.11.10	TITLE LOW FLOAT STEP END BRACKET
		REV. A SHEET 1 OF 1 SCALE 1:1

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NO. 27873
WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
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WITHOUT NOTICE